












Date: Wednesday, 12/12/2007 11:36:42 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BAFFLE ASSEMBLY
Job Number : 36270	
Estimate Number : 11264	
P.O. Number : <i>N/A</i>	Part Number : D3276041
This Issue : 12/12/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3276 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 12/12/2007 Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 30902	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 1/5/2008 Qty: 10 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:A New Issue 05-12-06 JLM Est Rev:B Now on Waterjet 06-09-06 JLM	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	M6061T6S040 6061-T6 .040 Sheet
	 
Comment: Qty.: 1.0715 sf(s)/Unit Total : 10.7153 sf(s) Material: 6061-T6 (QQ-A-250/11) 0.040" thick (M6061T6S.040) Batch: <i>165842</i> <i>1B 07-12-12</i>	
2.0	WATER JET FLOW WATER JET
	 
Comment: FLOW WATER JET 1-Cut as per Dwg D3276 Dwg Rev: <i>B</i> <i>1B 07-12-12</i> 10 Prog Rev: <i>B</i> 2-Deburr if necessary <i>1B 07-12-12</i>	
3.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	 <i>1B 07-12-12</i> 
Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8 SECOND CHECK
	  <i>9/12/13</i> x10 <i>conts</i>
Comment: SECOND CHECK	
5.0	SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1
	 
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr 2-Roll as per Dwg D3276 <i>SB 07/12/26</i>	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3276

SB 07/12/28

9

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12.27 9

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 07-12-28

9

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M106379

FL 07/12/28

9

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAD 07-12-31

9

11.0

D2464

3/4 Seal



Comment: Qty.: 2.2500 f(s)/Unit Total : 22.5000 f(s)

Pick:

Qty Part Number

Description Batch

27.0" D2464

Neoprene Seal

B30681

SAD

07-12-31

9

12.0

D32763

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3276-3

Decal

B26335

SAD

07-12-31

9

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3276

SAD

07-12-31

9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: A Date: 08/01/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/12/26	6	1 piece was scrapped at the set-up bend out of tolerance	<u>QS1042</u>	Scrap & destroy NO replace	<u>SS</u> <u>08/11/27</u>	<u>12-27</u>	<u>QS1042</u>	<u>QA-12-27</u>

NOTE: Date & initial all entries

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Drawing Name: BAFFLE ASSEMBLY

Job Number: 36270

Part Number: D3276041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/02 (49)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 220

AS

08/01/02

(49)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/01/03 (9)

Job Completion



2008/1/3

h

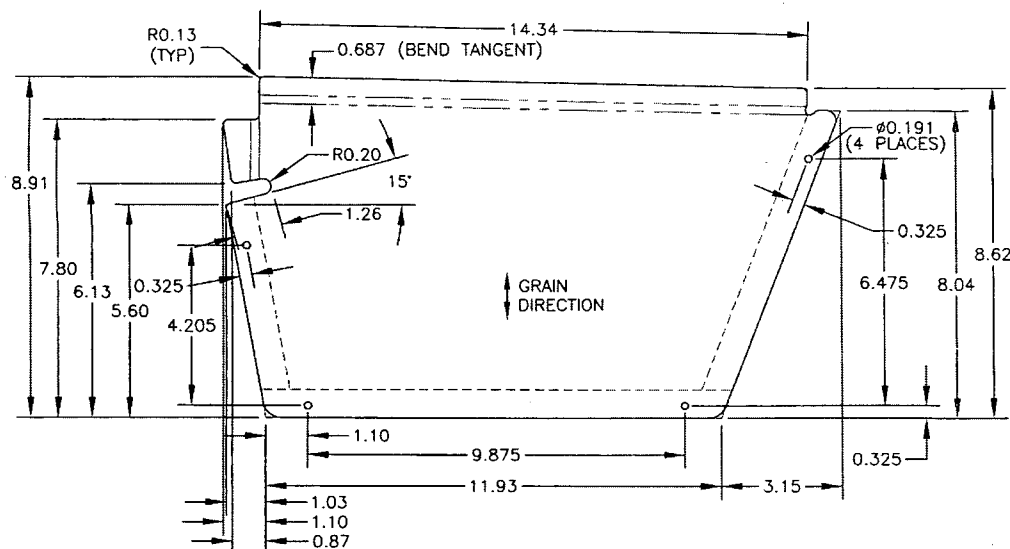
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

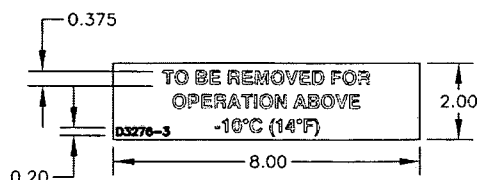
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3276-1 BAFFLE (FLAT PATTERN)

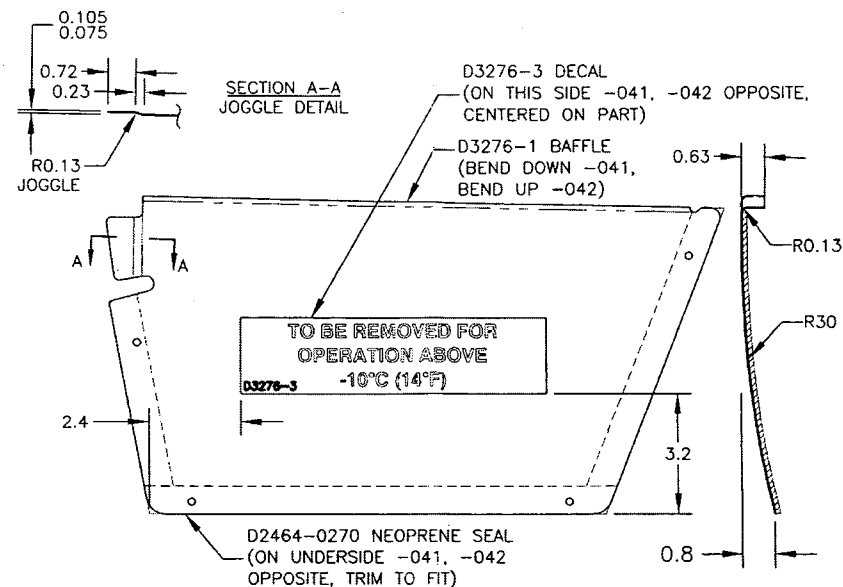
- 1) MACHINE PER DWG FILE "D3276-A.DWG"
- 2) MATERIAL: 6061-T6 ALUMINUM 0.040 THICK (QQ-A-250/11)
(REF DART SPEC. M6061T6S.040)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3276-3 DECAL

- 1) RED LETTERING ON WHITE ADHESIVE BACK
- 2) MANUFACTURE FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NO. 36270
 WORK ORDER
 SUBJECT TO ATTENDMENT
 WITHOUT NOTICE
 UNCONTROLLED COPY
 ENGINEERING
 RETURN TO
 SHOP COPY



D3276-041 BAFFLE ASSEMBLY, LH (SHOWN) D3276-042 BAFFLE ASSEMBLY, RH (BEND/JOGGLE OPPOSITE)

RELEASED
05.02.07

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B	05.01.25	LABEL NOW -10°C; CURVE PART
A	05.01.07	NEW ISSUE
DESIGN	CP	DRAWN BY CP
CHECKED	#	APPROVED
DATE	05.01.25	TITLE
		BAFFLE ASSEMBLY
		DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
		REV. B SHEET 1 OF 1 SCALE 1:3